DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials Quality Assurance and Source Inspection

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Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 70.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-007159 Address: 333 Burma Road **Date Inspected:** 13-Jun-2009

City: Oakland, CA 94607

OSM Arrival Time: 730 **Project Name:** SAS Superstructure **OSM Departure Time:** 1600 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Japan Steel Works **Location:** Muroran, Japan

CWI Name: CWI Present: Yes Chung Fu Kuan No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No **Weld Procedures Followed:** Yes No N/A **Qualified Welders:** Yes No N/A **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No Yes No N/A **Delayed / Cancelled:**

34-0006 **Bridge No: Component:** Tower, Jacking and Deviation Saddles

Summary of Items Observed:

On this date, 6/13/09, Caltrans OSM Quality Assurance Inspector (QAI) Mike Brcic was present during the times noted above for observations relative to the work being performed on cast sections and their associated built up plate sections in the Fabrication shop #4 and Foundry at Japan Steel Works (JSW), Muroran, Hokkaido, Japan.

WEST DEVIATION SADDLES

W2W1 - Casting is in process moving by JSW Riggers, casting did not get finally located before end of shift of QA Inspector's shift.

W2W2 - Cast section is in Fabrication Shop #4 having had 2 of 4 lugs welded, one at each end of the casting. The built up plate portion, which is located adjacent its mating casting, is having bevels cut by way of Oxygen and Propane automated rig on tracks. JSW employee, Mr. K.Minami has completed all but 4 ribs plate. The process was not underway during QA Inspectors review of shop operations.

W2W3 - Saddle Casting is observed as idle in Foundry. During QA Inspector's observances JSW personnel were only grinding the reinforcement for inspection, both visual and NDT. No welding occurred during A Shift, on this plate section for W2W3.

TOWER SADDLES

T1-3 - Observations of QA Inspector were noted as follows: Repair of CJP joint 9Y-5U-2 had been completed and information relayed to QC CWI C.Kuan, from QC CWI M.Ashadi, was the weld parameters and welder information. Procedure used was SJ-3012-9 by K.Nakasato 91-2247, SMAW, E7016 4mm electrode. Upon

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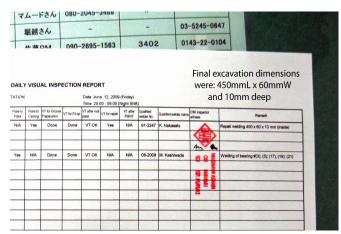
arrival the weld cap (reinforcement) had been carbon arced and yet to be ground (see photo). Upon departure the weld reinforcement had been ground is awaiting a verification UT of repair area.

EAST SADDLES

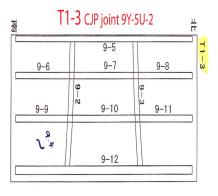
E2W1 - As observed by QA Inspector, welder, H.Sato 69-2697 is performing weld repair of excavations, and light areas. SMAW procedure followed was SJ-3026-4 using 4mm E9016 electrode. In Fabrication Shop #4, welder, Mr. Y. Watanabe 73-3873, was fillet welding (15mm) with SMAW E7016 4mm electrode #21-4 blocks to 21-1 bearing plate. Mr. Chung Fu Kuan, QC CWI randomly assure compliance to procedure SJ-3177-4.

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.









Summary of Conversations:

No significant conversations to report on this day.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for your project.

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Inspected By:	Brcic,Michael	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer